

Date: Wednesday, 30/01/2008 7:52:06 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FLOOR PROTCTOR AFT LH		
Job Number	: 37110			Part Number	: D32813		
Estimate Number	: 11228			Drawing Number	: D3281 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 30/01/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: THERMOFORMING	Due Date	: 06/02/2008	Qty:	2
Previous Run	: 35248			Um:	Each		
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	F6006 701	lexan black	
		Comment: Qty.: 4.0000 sf(s)/Unit Total : 8.0000 sf(s) lexan black	M 102957
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
		Comment: HAND FINISHING THERMOFORMING	
	1) Cut Blanks		B 08/01/30
3.0	THERMOFORMING	THERMOFORMING MACHINE	
		Comment: THERMOFORMING MACHINE	
		Thermoform as per Dwg. D32811and Folio FTA 009	X 2
	Dwg. Rev. <u>"C"</u>		
	Folio Rev. <u>3</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	B 08/01/30
5.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
		Comment: HAND FINISHING THERMOFORMING	X 2
	1) Trim to Finished Dimensions		B 08-01-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/01/2008 7:52:06 AM
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Drawing Name: FLOOR PROTCTOR AFT LH

Job Number: 37110

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



x2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

- 1) Check Surface finish for undesired marks, voids, dimples etc.
- 2) Check dimensions to ensure conformity to drawing tolerances.

Dr. 08.01.30

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/01/30 (2)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



267

8/1/30 SD

(2)

Comment: PACKAGING RESOURCE #1

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



L 08/01.30

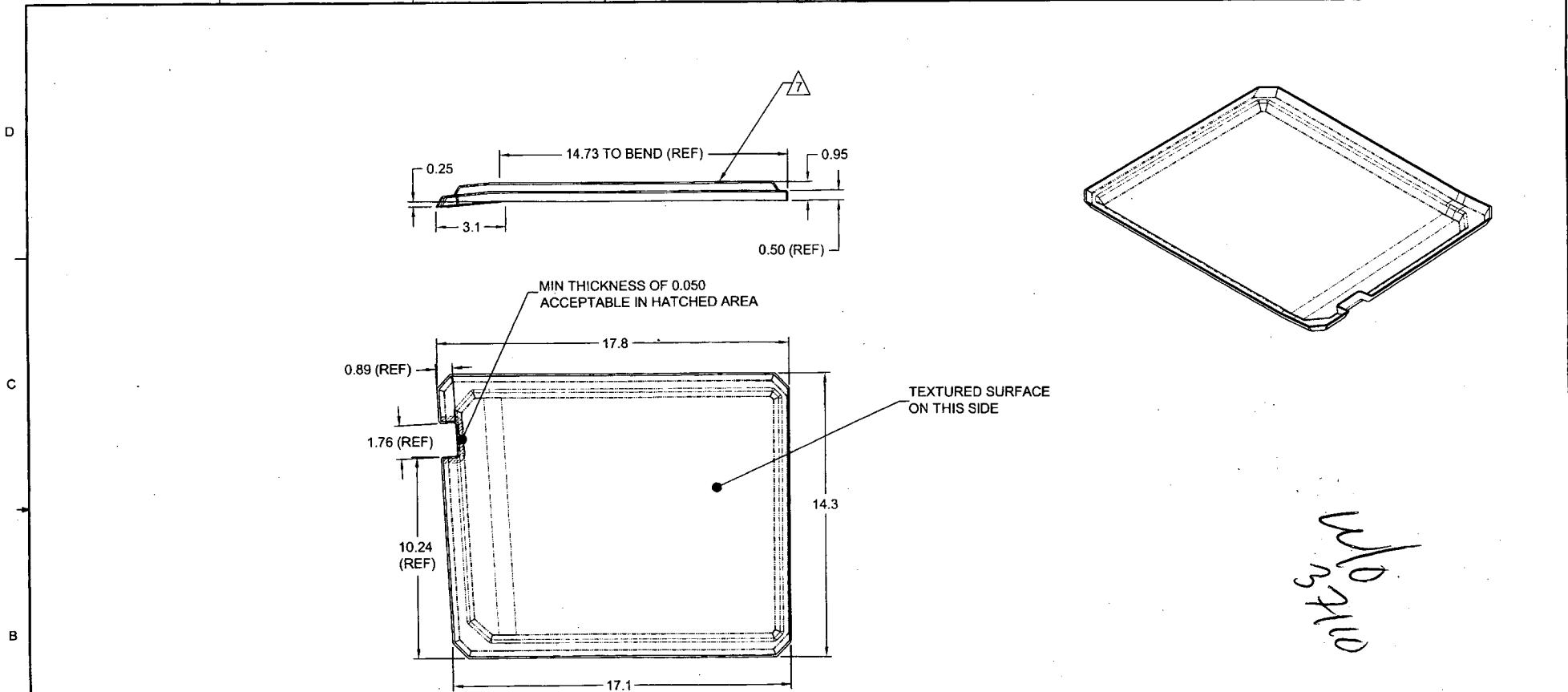
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



RELEASED
07-11-06

D3281-3 FLOOR PROTECTOR
(D3281-4 OPPOSITE)

D3281-3/4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 FOR D3281-3 AND D3281-4T1 FOR D3281-4 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3/4" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1lb

DESIGN	<i>RP</i>	DART AEROSPACE LTD	
DRAWN	<i>LE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PB</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>WJ</i>	D3281	SHEET 3 OF 3
APPROVED	<i>JM</i>	TITLE	SCALE
DE APPR.	<i>SL</i>	FLOOR PROTECTOR	NTS
DATE	07.10.09	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

DART AEROSPACE LTD	WORK ORDER:	37110
Description: A44 FLOOR PROTECTOR AFT LH	Part Number:	D 32813
Inspection Dwg: D3281 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

(Step 4) Thermoforming Visual Inspection Sign-off

Description	Initials
Inside Radii less than 3/16" go/no go	DL
Acceptable shape definition	SH
Acceptable texture retention	SLy
Free of visual flaws (bumps, cracks, voids, etc.)	WTC

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3281 Rev.C and record below

Measured by:	<u>JL</u>	Audited by:	<u>J</u>	Prototype Approval:	<u>.1</u>
Date:	08.01.30	Date:	08.01.30	Date:	19

Rev	Date	Change	Revised by	Approved
		New Issue		